

Work Order ID 152024

Wednesday, October 19, 2016 7:57:28 AM

152024

Page 1

Item ID: D4060-7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw Clamp
 Start Date: 10/19/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 10/20/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: dm Date: 10/10/19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4060	pc11 <u>C</u> <u>10/10/19</u>								
100		0.00							
100									
Waterjet	Memo	0.08				(10)			<u>pc 10/10/19</u>
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.02				(10)			<u>pc 10/10/19</u>
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.03				10			
Quality Control									

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Wednesday, October 19, 2016 7:57:28 AM

Page 2

OCT 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

Wednesday, October 19, 2016 7:57:28 AM

Page 3

Stop ***NR2***

**Insp.
Stamp**

0.17

Quality Control

Vs 16/10/20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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OTHER : ☐					

Picklist Print

Wednesday, October 19, 2016 7:57:28 AM

Work Order ID: 152024

152024

Parent Item: D4060-7

D4060-7

Parent Item Name: Bearpaw Clamp

Start Date: 10/19/2016

Required Date: 10/20/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 16.08.15 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased	No				sf	43.7900	AA	0.538947 0.98			
M304S14GA													
304SS sheet .080													

on 10/19/19

Location

Loc Qty

Loc Code

MAT019

43.79

M129972

5.7

M135061

3.69

M135689

2.4

M135860

32

1.2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : ☐						

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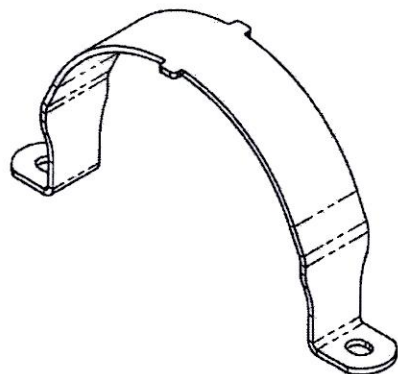
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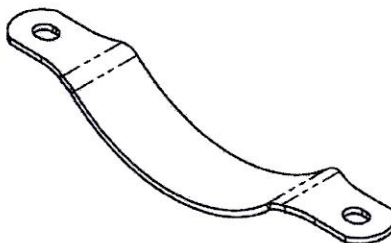
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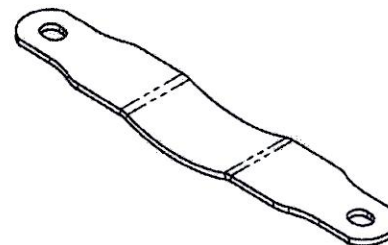
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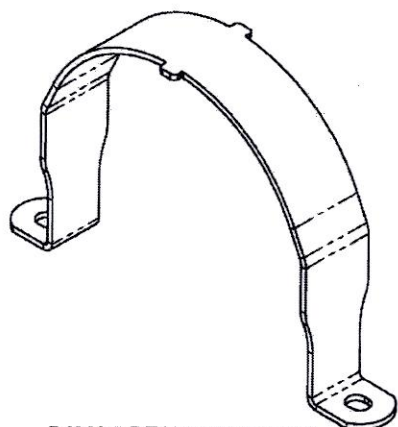
D4060-1 412 SKI CLAMP, TOP



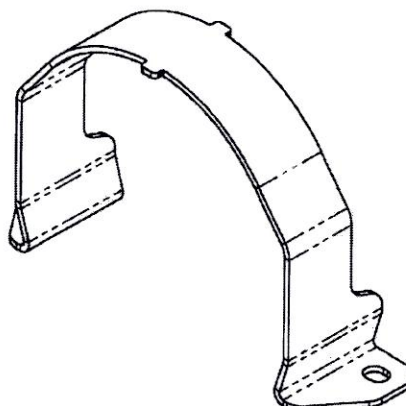
D4060-3 412 SKI CLAMP, BOTTOM



D4060-5 412 SKI CLAMP, AFT



D4060-7 BEARPAW CLAMP



D4060-9 AFT BEARPAW CLAMP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 153024

dm 16/10/19

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5613 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: D4060-1/-7 = 0.23 lbs, D4060-3/-5 = 0.12 lbs, D4060-9 = 0.28

RELEASED
2016-10-18
BEN-654

C	ADD -7 & -9. REASON: CIR16-87. ADD "REF" FOR BEND LINES.	AJS	16.05.09
B	ADD CUSHION RETENTION DETAILS TO -1 CLAMP, REASON: PAR 14-368, PAR 14-331, NGR 14-3521	VS	15.05.14
A	NEW ISSUE	MB	10.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4060 TITLE 412 SKI CLAMP COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE BASIS OF THE INFORMATION CONTAINED HEREIN. NOT TO BE USED FOR ANY PURPOSE OR GROUP, OR CONSIDERED TO ANY OTHER PERSON OR ENTITY. BRIEFED PERSONNEL FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED	ML		
MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	DS	REV. C SHEET 1 OF 6 SCALE NTS	
DATE	16.05.09		

8

7

6

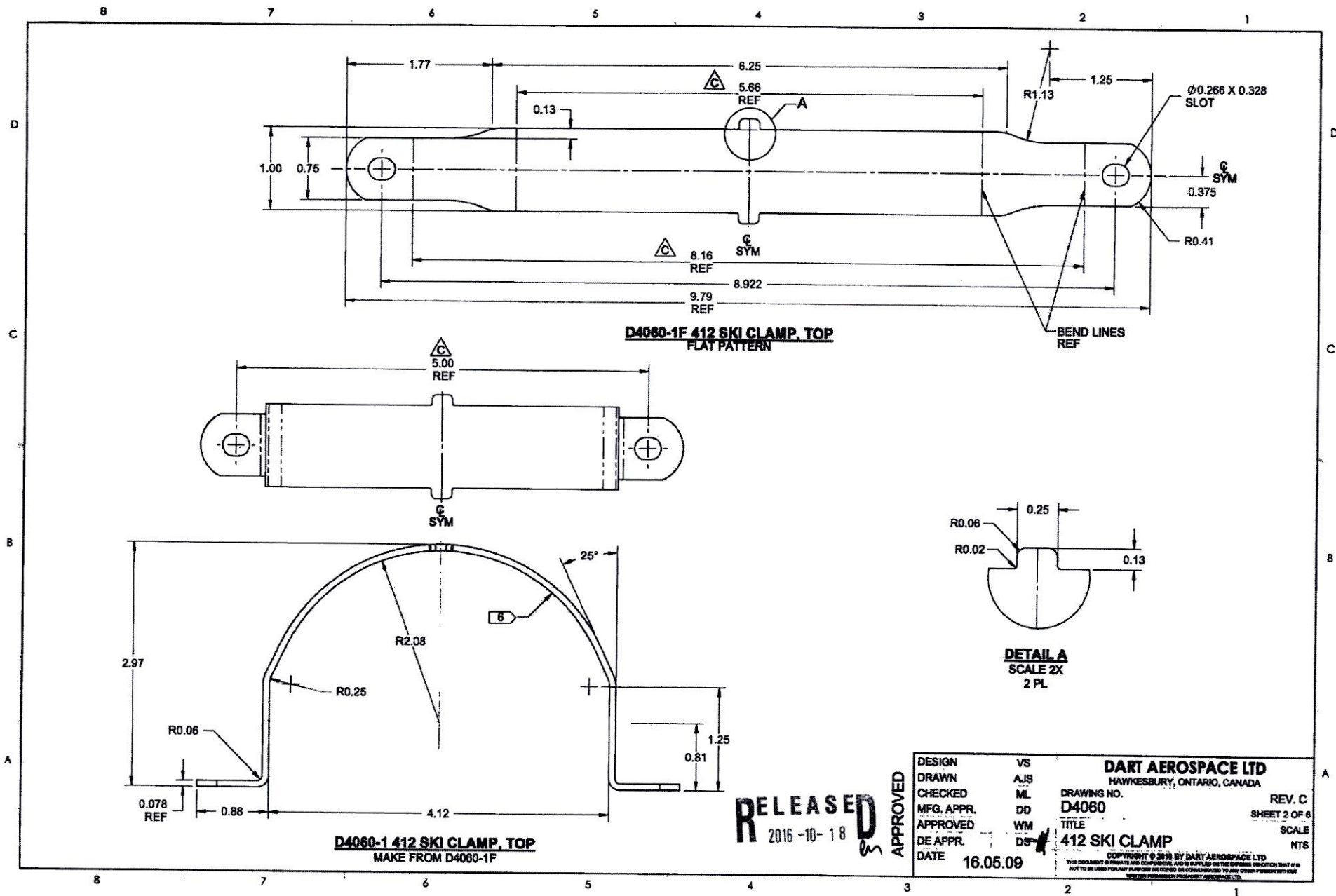
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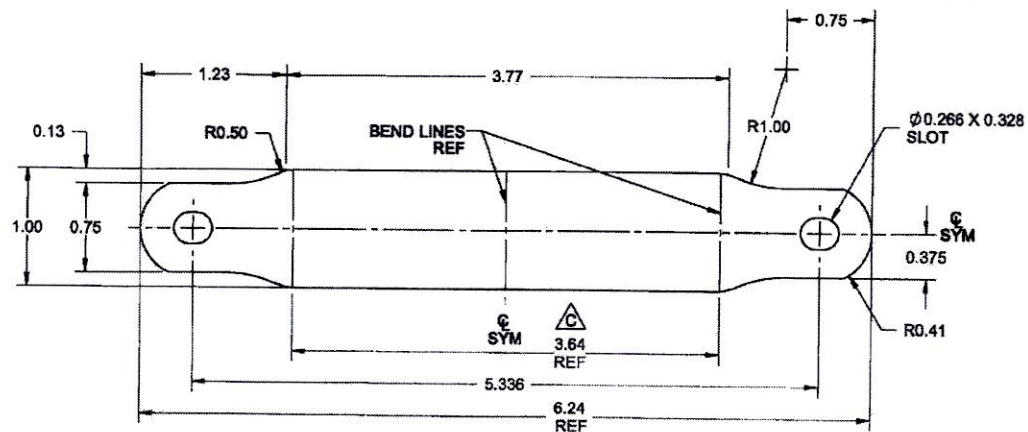
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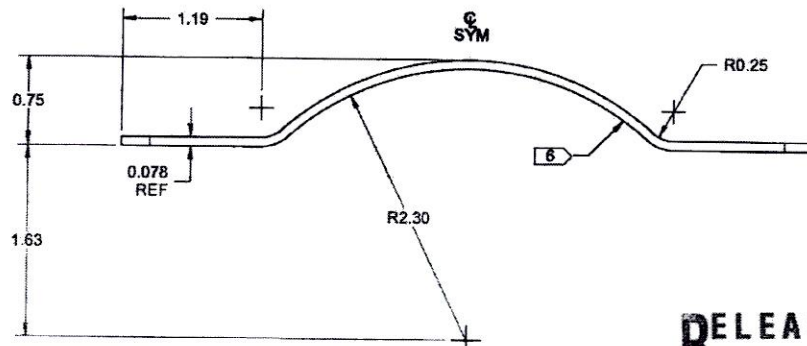
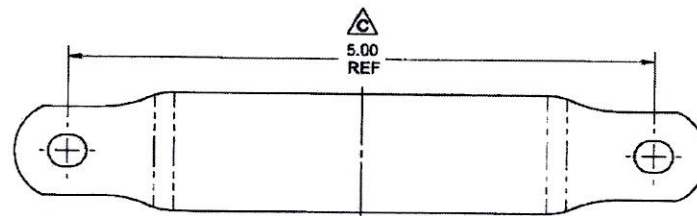
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1





D4060-3F 412 SKI CLAMP, BOTTOM
FLAT PATTERN



D4060-3 412 SKI CLAMP, BOTTOM
MAKE FROM D4060-3F

RELEASED
2016-10-18

APPROVED

DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE

VS
AJS
ML
DD
WM
DS

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4060

TITLE
412 SKI CLAMP

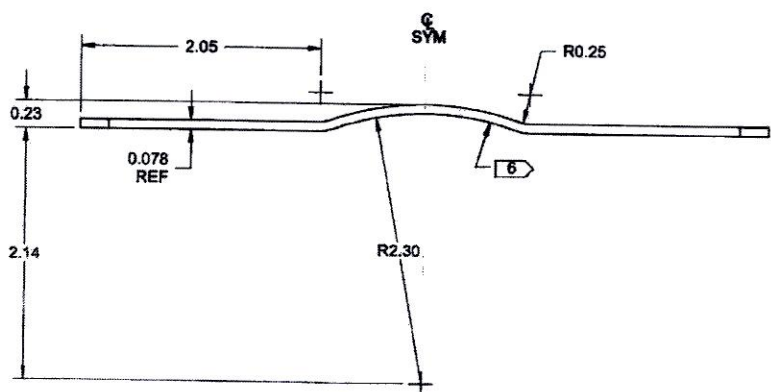
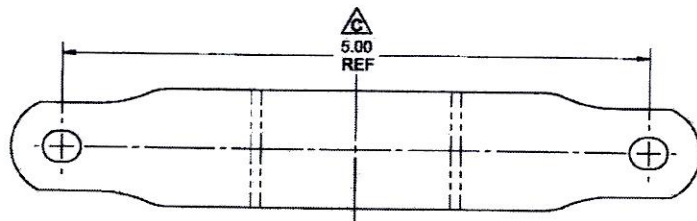
REV. C
SHEET 3 OF 8
SCALE
NTS

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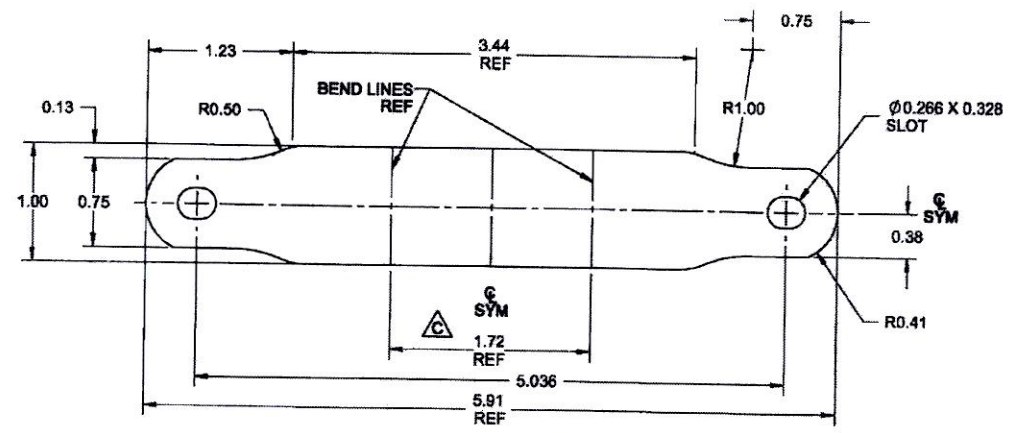
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D
C
B
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D
C
B
A



D4060-5 412 SKI CLAMP. AFT
MAKE FROM D4060-6F



D4060-5F 412 SKI CLAMP. AFT
FLAT PATTERN

RELEASED
2016-10-18

APPROVED

DESIGN	VS
DRAWN	AJS
CHECKED	ML
MFG. APPR.	DD
APPROVED	WM
DE APPR.	DS
DATE	16.05.09

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HAWKESBURY, ONTARIO, CANADA

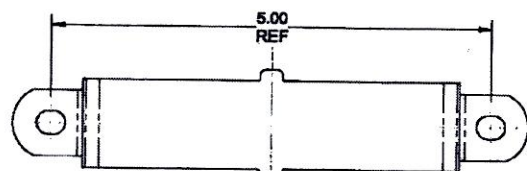
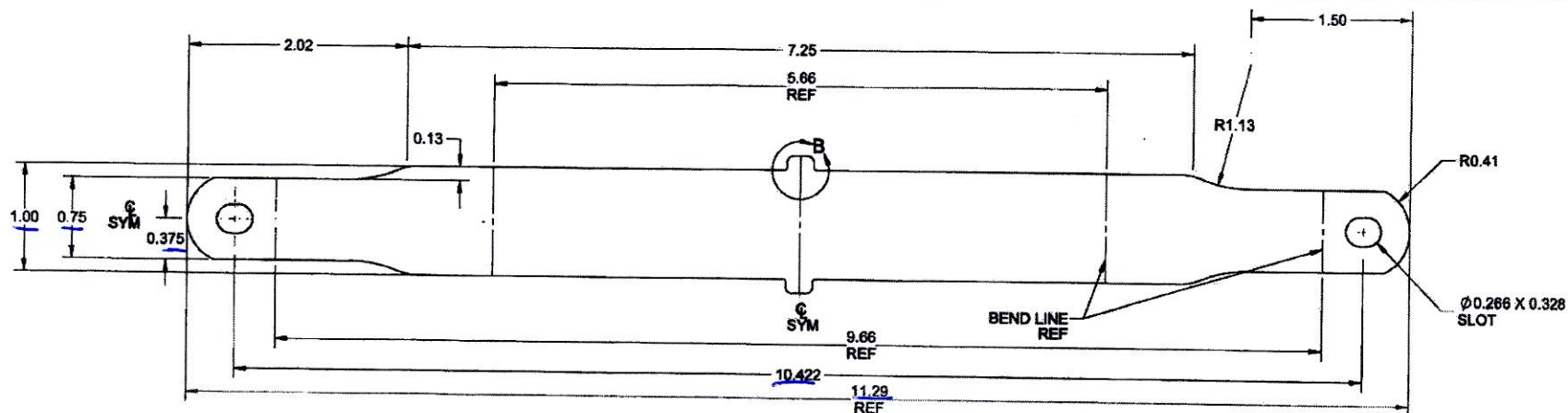
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TITLE **412 SKI CLAMP**

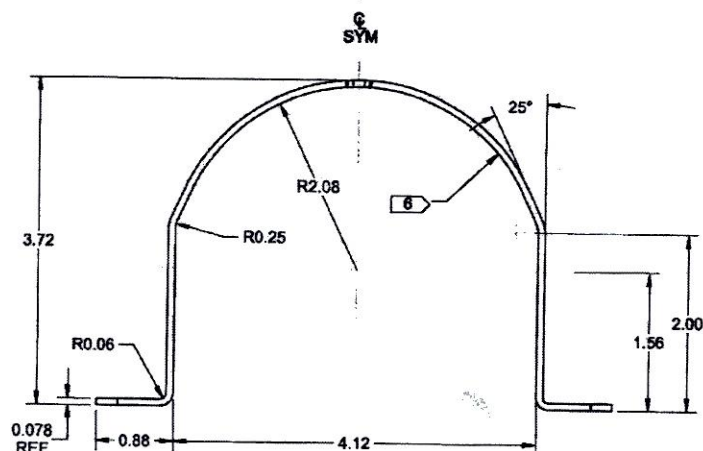
REV. C
SHEET 4 OF 6
SCALE
NTS

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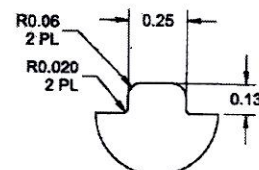
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D4060-7F BEARPAW CLAMP
FLAT PATTERN



D4060-7 BEARPAW CLAMP
MAKE FROM D4060-7F



DETAIL B
SCALE 2X
2 PL

RELEASED
2016-10-18

APPROVED

DESIGN	VS
DRAWN	AJS
CHECKED	ML
MFG. APPR.	DD
APPROVED	WM
DE APPR.	DS
DATE	16.05.09

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4060**

TITLE **412 SKI CLAMP**

REV. C
SHEET 5 OF 8
SCALE
NTS

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